

Work Order ID 99273

Friday, April 05, 2013 10:11:47 AM

99273

Page 1

Item ID: D3021-043

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tube Assembly

Start Date: 4/5/2013 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/8/2013 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

MUF

Date:

2-4-5

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D3021

B

100

0.00

4 EL 13-4-10

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut tube as per Dwg D3021

2-Drill tube as per Dwg D3021 using DT8622

3-Deburr

4-Weld stud and end cap as per Dwg D3021 QSI004

A/R 4130 Rod Batch: *M114875*

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

13-04-10 *DA*
09
2-88

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Page 2

Item ID: D3021-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Tube Assembly

Stop ***NS2***

Start Date: 4/5/2013 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/8/2013 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

④ 13-04-10 DAS 09 2-88

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

130

Powdercoat

Memo

0.00

Powder Coating

*** MASK THREAD PRIOR TO POWDERCOAT***

START TIME: 1:15

OVEN TEMPERATURE: 320°F

FINISH TIME: 1:45

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

4x d m/f 13/04/15

4x d m/f 13/04/15

M122966

Work Order ID 99273

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Page 3

Item ID: D3021-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tube Assembly

Start Date: 4/5/2013 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/8/2013 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

150

Identify as per dwg & Stock Location: **8253** 0.00***150***

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release 0.00

160

QC

Memo

0.00

Quality Control

4X**SP**
13-4-16**13/4/17****13-04-17**

Picklist Print

Friday, April 05, 2013 10:11:46 AM

Page 1

Work Order ID: 99273

Parent Item: D3021-043

Parent Item Name: Tube Assembly

Start Date: 4/5/2013

Required Date: 4/8/2013

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.06.11 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3017-11 cap		Manufactured	No			100	Each	30.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA002		30							
				91837		30							
D4667-041 Armrest Stud Assembly		Manufactured	No			100	Each	8.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA003		8							
				92331		8							
M4130NT0.750W.049 4130 RD Tube .750 x.049W		Purchased	No			100	f	42.4218	2.325	9.7894737			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT033		42.4217893							
				123339		6.6217893							
				124293		35.8							

EL 13-4-10

1 4 1

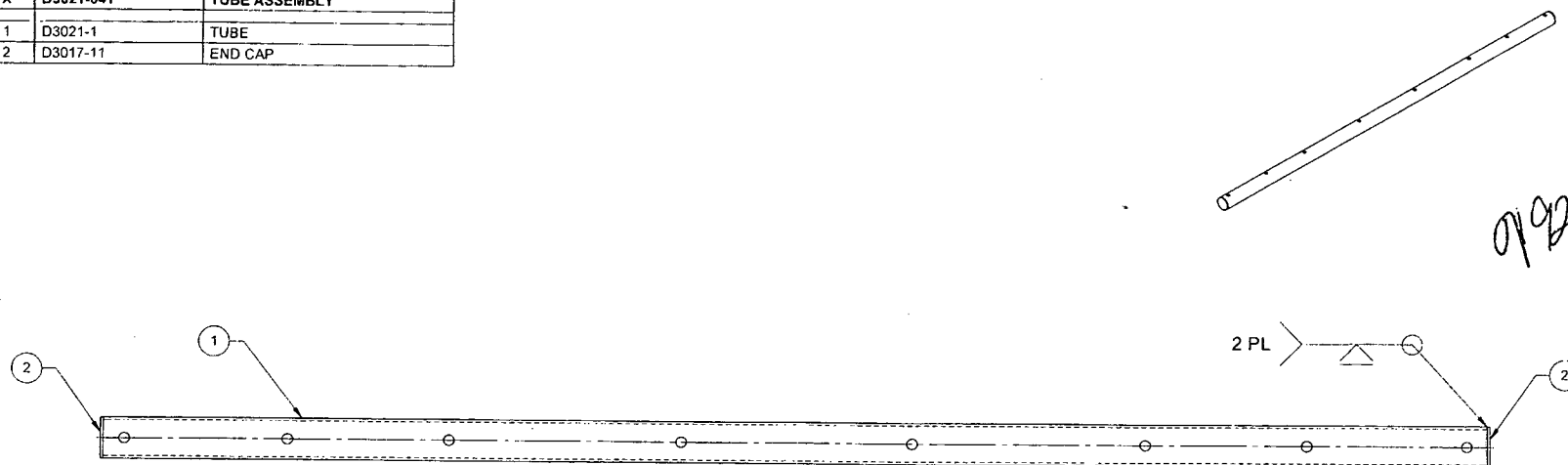
EL 13-4-10

4

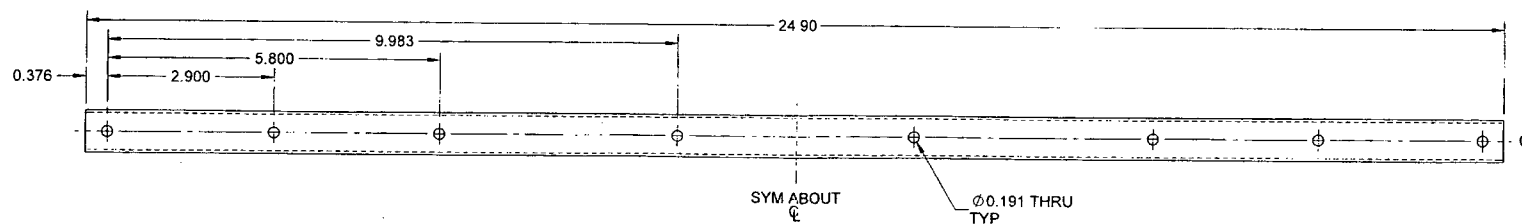
EL 13-4-10

9.78

ITEM	QTY	P/N	DESCRIPTION
	X	D3021-041	TUBE ASSEMBLY
1	1	D3021-1	TUBE
2	2	D3017-11	END CAP



D3021-041 TUBE ASSEMBLY



D3021-1 TUBE

NOTES:

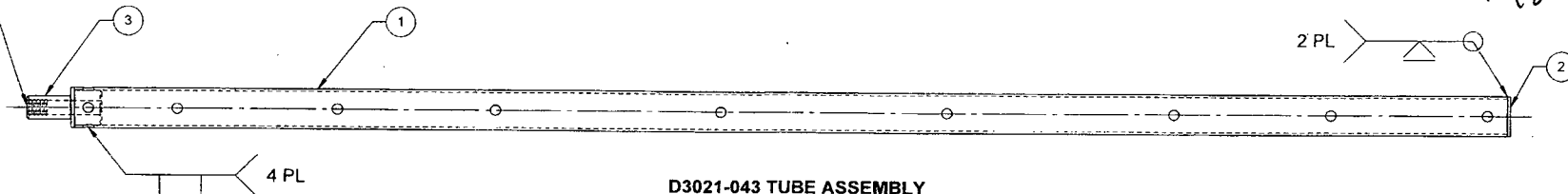
- 1) MATERIAL -041: N/A
-1: AISI 4130N SEAMLESS STEEL TUBING, $\phi 0.750 \times 0.049$ WALL
PER MIL-T-6736 OR AMS 6371/6360/6361/6362/6373/6374
REF M4130NT0.750W.049
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3021-041" AND B/N "BXXXXX"
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 0.77 lbs

RELEASED
2012-07-03
4 PER EN 12-616

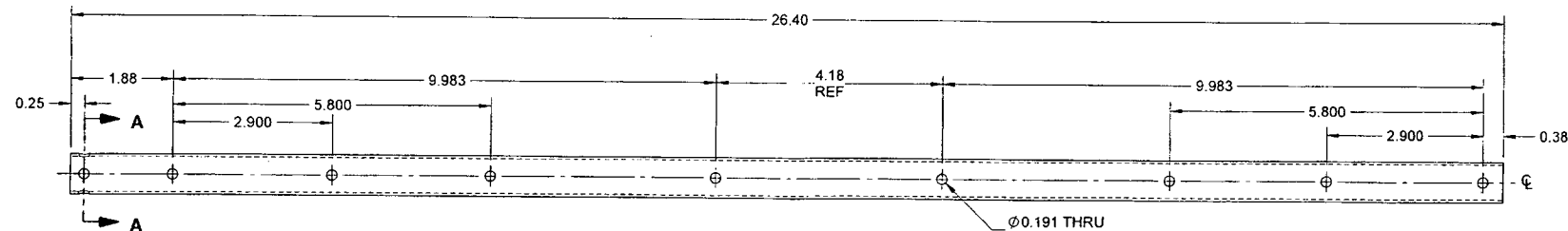
B	REFORMAT, ADDED -043 & -3	AJS	12.06.12
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3021	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TUBE ASSEMBLY	NTS
DATE	12.06.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

ITEM	-043 QTY	P/N	DESCRIPTION
	X	D3021-043	TUBE ASSEMBLY
1	1	D3021-3	TUBE
2	1	D3017-11	END CAP
3	1	D4667-041	ARMREST STUD ASSY

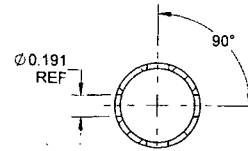
MASK THREAD PRIOR
TO POWDER COAT



D3021-043 TUBE ASSEMBLY



D3021-3 TUBE



NOTES:

- 1) MATERIAL -043: N/A
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3021-043" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 0.88 lbs

SECTION A-A

SCALE 2X

RELEASED
2012-07-03

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	[Signature]	DRAWING NO.	REV. B
MFG. APPR.	[Signature]	D3021	SHEET 2 OF 2
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	TUBE ASSEMBLY	NTS
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